

Work Order ID 56372

Monday, February 22, 2010 8:12:34 AM

Page 1

Item ID: D350-591-214UP

Accept

Setup Start

Revision ID:

Item Name: Heli-Access-Step, Short RH

Stop

Start Date: 2/22/2010 Start Qty: 1.00

Required Date: 2/23/2010 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-591-214 CHG003

MF 10-2-22

8/10/02/22

110

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut D2622-120 extrusion to 59.75" long as per Dwg D3078
2-Drill extrusion as per Dwg D3078 using Jig DT8680 for rivets.
3-Deburr

Ph 10.02.22

120

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

8/10/02/22

70

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Page 2

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Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
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Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00



Large Fab

Large Fab

Memo

0.00

1-Bevel end for welding FWD ONLY
2-Weld Support using Jig DT8681, weld Fwd End Plate as per QSI 004 & Dwg D3078
A/RAluminum Rod M11131
3-Grind End Plate flush

10.02.22

140

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

①

10.02.22

150

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/22

7/

RH

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Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control



10-02-22

SAD
10-02-22

⑦

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

200

0.00



Large Fab

Large Fab

Memo

0.00

1- Rivet Leg Assembly as per Dwg D3078.

2-Bevel Aft end for welding

3-Inspect for foreign object as per QSI 024

4-Weld Aft End Plate as per QSI 004 & Dwg D3078

A/R Aluminum Rod *mill 34*

5-Grind End Plate flush

2/10-02-22

1 0

210

0.00



QC9- Inspect visual per QSI004- Fusion Welds

QC

Memo

0.00

Quality Control

1 0 BE 09/02/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

230

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

250

Wing Walk as per dwg QSI005 4.4 Batch

0.00



HandFinish

Memo

0.00

Hand Finishing

attn: unpainted

8 10/02/22

PK 10-02-22

u/a 8

+1 RH

1 RH

P10 ->

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D350-591-214 UP PAR #: _____ Fault Category: Large Frg NCR: Yes No DQA: _____ Date: 10-03-02
 Resolution: re-work Disposition: re-work QA: N/C Closed: JS Date: 10/03/02

NCR: <u>56372</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/02/22	# 220	During inspection Found/heard a foreign object on side the welder step. It wasn't clear enough before welding R.C: LACK of Attention.	<u>JS</u>	Drill 1/8" hole in AFT end cap + remove object. - fill in hole with weld as per 252 004 A/R <u>MILL311</u>	<u>JS</u> 10-02-22	<u>S</u> 10/02/22	<u>JS</u>	<u>S</u> 10/02/22
			<u>JS</u>	- Buff weld smooth	<u>JS</u> 10-02-22	<u>S</u> 10/02/22	<u>JS</u>	<u>S</u> 10/02/22

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Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

260

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

270

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

280

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control



Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop



⇒ M-1

10/02/22

(1X)

10-2-29

sl

8.10.02/27

(+)
RHC

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Required Date: 2/23/2010 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

290

0.00



Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D350-591-214

Location:

PPP Rev:

300

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10-2-2950

100022

mf
10-2-22

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Comments:

Start Date: 2/22/2010

Required Date: 2/23/2010

Start Qty: 1.00

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN3-35A Purchased

No

Each

197.0000

2.0000



Bolt



10-2-298

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

197

106993

12

110467

1

112314

184

AN4-11A Purchased

No

Each

422.0000

6.0000



Bolt



10-2-29 5

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

422

110382

422

AN4-13A Purchased

No

Each

247.0000

4.0000



Bolt



10-2-29 4

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

247

113359

47

113749

200

17406

0

51764

0

Dart Aerospace Ltd

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Start Qty: 1.00

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---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN4-16A

Purchased

No

Each

75.0000

4.0000

Bolt

102-29 SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

75

112969

73

18949

2

Each

0.0000

4.0000

AN960JD10

Purchased

No

Washer

AN960JD416

Purchased

No

Each

0.0000

12.0000

Washer

D2230-1

Manufactured

No

Each

116.0000

2.0000

Lug

4

M113288 10-2-29 SP

M113706 SP

B54755 10-2-29 SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

4

51761

4

Main Warehouse

ST476

112

54755

112

Dart Aerospace Ltd

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Required Qty: 1.00

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---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2230-3 Manufactured No

Each 39.0000 2.0000



Lug



10-2-295

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

7

50306

5

51568

2

Main Warehouse

ST476

32

55310

32

D2622-120C

Manufactured No

Each 156.7400 0.5000



Step Extrusion



2

10.02.22

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

156.74

48612

3.12

52026

30.62

55214

123

Monday, February 22, 2010 8:12:34 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
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---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2732		Manufactured	No				f	98.0410	1.0000			
-------	--	--------------	----	--	--	--	---	---------	--------	--	--	--



Rubber Extrusion

10-2-29 SL

Warehouse Location	Loc Qty	Loc Code
-----------------------	---------	----------

Main Warehouse

ST	98.041	
----	--------	--

38509	20.62	
-------	-------	--

43118	77.421	
-------	--------	--

Cut 3.00" long, qty 4 - measure 5/10/12 24		Manufactured	No				f	257.7521	0.6000			
--	--	--------------	----	--	--	--	---	----------	--------	--	--	--



Abraison Strip

10-2-29 SL

Warehouse Location	Loc Qty	Loc Code
-----------------------	---------	----------

Main Warehouse

ST403	257.7520842	
-------	-------------	--

50593	141.312084	
-------	------------	--

52563	116.44	
-------	--------	--

cut 7.20' long, qty 1 - measure 5/10/12 24		Manufactured	No				Each	23.0000	1.0000			
--	--	--------------	----	--	--	--	------	---------	--------	--	--	--



Support

10-2-29 SL

Warehouse Location	Loc Qty	Loc Code
-----------------------	---------	----------

Main Warehouse

ST	23	
----	----	--

51237	23	
-------	----	--

Monday, February 22, 2010 8:12:34 AM

Shop Packet Print

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D3065-041
Step Leg Assembly Hi

Manufactured

No

Each

58.0000

1.0000



10.02.22

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

58

53795

28

55450

30

D3066-1

Manufactured

No

Each

38.0000

2.0000



10.02.22

Spacer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

38

51545

11

53783

27

D3067-1

Manufactured

No

Each

49.0000

1.0000



10.02.22

End Plate

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

49

53784

49

Monday, February 22, 2010 8:12:34 AM

Shop Packet Print

Page 5

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D3067-1  End Plate		Manufactured	No				Each	49.0000	1.0000			

10.02.22

Warehouse
Location

Main Warehouse

ST

49

53784

49

Each

1,171.000 16.0000

1

MS20600-AD4W4

Purchased

No



Rivets



10.02.22

Warehouse
Location

Main Warehouse

ST

1171

110731

215

111359

46

111477

74

112314

312

112385

24

113368

500

16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MS21042L3

Purchased

No

Each

2,606.000

2.0000



10-2-29 sf

Nut

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

2600

110844

35

111274

27

111668

52

112314

285

112385

481

113523

20

113537

700

113644

1000

Main Warehouse

ST139

6

111668

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, February 22, 2010 8:12:34 AM

Work Order ID: 56372

Parent Item: D350-591-214UP

Parent Item Name: Heli-Access-Step, Short RH

Start Date: 2/22/2010

Required Date: 2/23/2010

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
S MS21042L4 Nut		Purchased	No				Each	2,185.000	6.0000			

10-2-29 SP

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	2185	
102552	6	
104248	6	
110507	184	
141827	995	
113422	994	
15924	0	



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3078	REV. A SHEET 1 OF 2
DATE 02.09.11		TITLE STEP ASSEMBLY, HI SHORT SCALE NTS	
A	02.09.11	NEW ISSUE	

RELEASED
02.09.20 *CP*

#56378

Part No.	Description	QTY -041	QTY -042
D3078-041	Step Assembly, High Short (LH)	X	
D3078-042	Step Assembly, High Short (RH)		X
D2622-60	STEP EXTRUSION	1	1
D3063-1	SUPPORT	1	1
D3065-041	LEG ASSEMBLY	1	1
D3066-1	SPACER	2	2
D3067-1	END PLATE	2	2
MS20600AD4W4	RIVET	16	16

GENERAL NOTES:

- 1) -041 SHOWN, FOR -042 INSTALL D3063-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

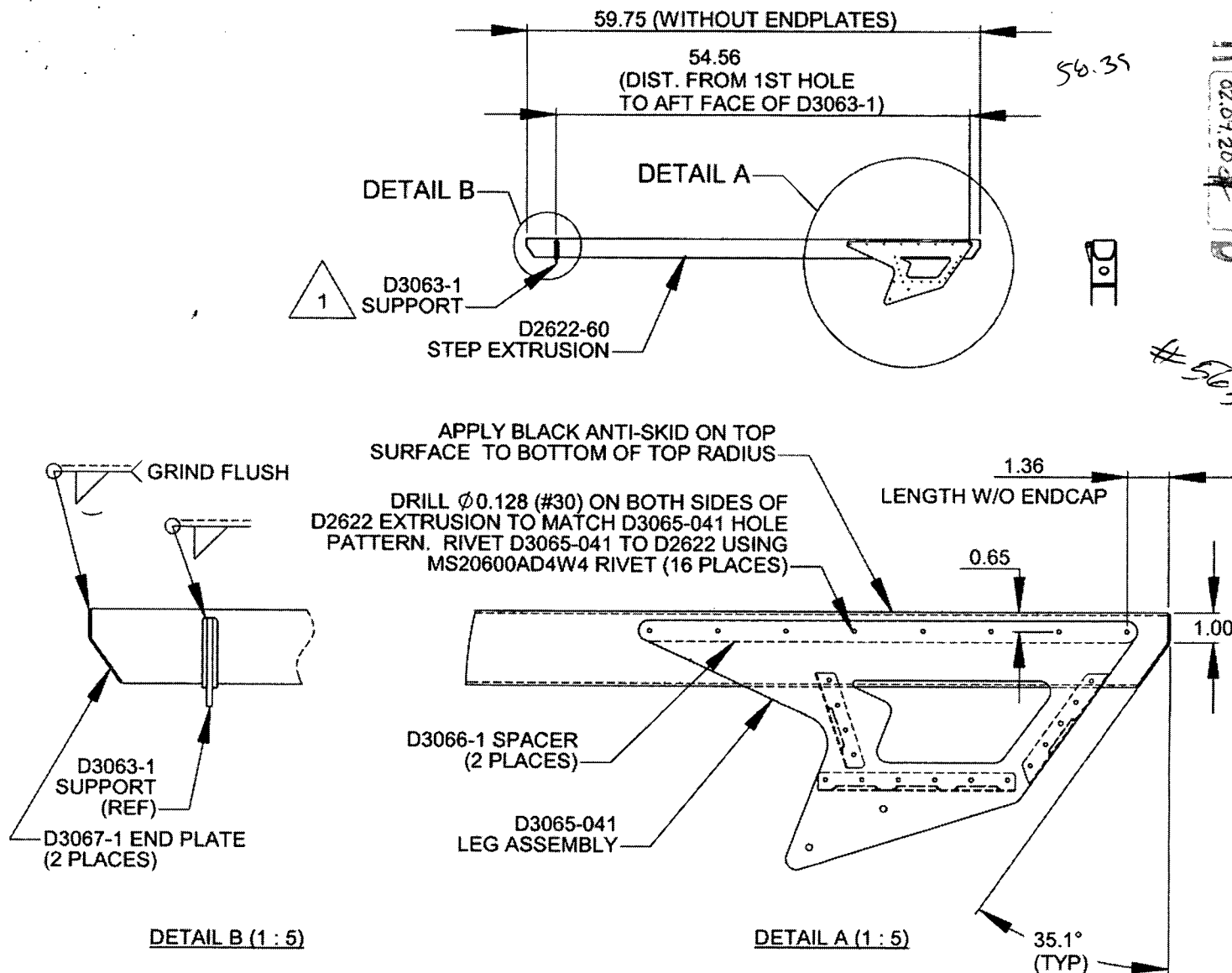
NOTE: Date & initial all entries

DART

DESIGN	<i>CP</i>	DRAWN BY	<i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>CP</i>	APPROVED	<i>CP</i>	DRAWING NO. D3078
DATE	02.09.11	TITLE	STEP ASSEMBLY, HI SHORT	REV. A SHEET 2 OF 2
		SCALE	1:20	

RELEASED
02.09.2011

#56370



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries